

Date: Tuesday, 1/16/2007 11:29:26 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206/OH-58 SADDLE, OUTBOARD, LEFT SIDE		
Job Number	: 30280		Part Number	: D29321		
Estimate Number	: 10831		Drawing Number	: D2932 UNDER REVIEW <i>OK</i> <i>9</i> <i>07.01.16</i>		
P.O. Number	: <i>N/A</i>		Project Number	: N/A		
This Issue	: 1/16/2007		Drawing Revision	: B		
Prsht Rev.	: NC		Material	: <i>N/A</i>		
First Issue	: <i>N/A</i>		Due Date	: 1/30/2007		
Previous Run	: 29230		Qty:	10		
Written By	: <i>JK</i> <i>✓</i>		Um:	Each		
Checked & Approved By	: <i>JK</i> <i>07.01.16</i>					
Comment	: Est: B 00106.26 New DWG rev, (mpp 2069) EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101003	7075-T7351 2X6.25X7.875	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) 7075-T7351 2X6.25X7.875 Issue material from stock: 7075-T7351 Cut Size 2.0 x 6.25 X 7.880 Grain Along Long 7.88 Length Batch No: <i>325346</i>	<i>JK</i> <i>07/01/21</i> <i>16</i>
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 5-Deburr & TUMBLE	<i>JK</i> <i>07/01/21</i> <i>10</i>
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet	<i>JK</i> <i>07/02/02</i>
4.0	QC1	INSPECT ALL DIM TO DIM SHEET	
		Comment: INSPECT ALL DIM TO DIM SHEET	<i>JK</i> <i>07/01/21</i> <i>10</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07.01.16	2	TOOL RAD FOR FLANGE PACKETS SHOULD BE R0.188 AS MARKED UP DN DWG				CP 07.01.16 DS1042	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/02/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 1/16/2007 11:29:26 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, OUTBOARD, LEFT SIDE

Job Number: 30280

Part Number: D29321

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

SA 07.02.05

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

a.m 07/02/05

(10)

7.0 POWDER COATING

POWDER COATING



M103141

(10)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m.b/41

07/02/05

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

PC 7/02/12 (10)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: STY19

PC 7/02/12 (10)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

PC 7/02/13 (10)

Job Completion



U 07.02.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	30280
Description: 206 Saddle, Outboard, Left side		Part Number:	D2932-1
Inspection Dwg: D2932 Rev. B			Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. B and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.128	0.128	0.130	0.128		
B	0.100	0.140		0.129	0.129	0.130	0.128		
C	0.100	0.140		0.125	0.124	0.120	0.124		
D	0.210	0.230		0.223	0.223	0.223	0.224		
E	1.245	1.255		1.250	1.249	1.249	1.249		
F	1.245	1.255		1.250	1.249	1.249	1.249		
G	2.495	2.505		2.499	2.499	2.499	2.506		
H	0.510	0.515		.514	.514	.514	.514		
I	1.572	1.582		1.576	1.576	1.576	1.575		
J	2.495	2.505		2.498	2.499	2.499	2.500		
K	0.257	0.262	DT8683	0.258	0.258	0.258	0.258		
L	0.312	0.317	DT8686	0.314	0.314	0.314	0.314		
M	0.235	0.240		.237	.237	.237	.237		
N	0.100	0.140		0.123	0.123	0.124	0.124		
O	0.540	0.560		0.546	0.546	0.550	0.550		
P	0.490	0.510		0.501	0.500	0.504	0.502		
Q	3.715	3.725		3.718	3.719	3.718	3.717		
R	2.470	2.510		2.498	2.490	2.498	2.490		
S	0.240	0.270		0.252	0.253	0.253	0.252		
T	0.100	0.180		0.141	0.141	0.140	0.140		
U	1.625	1.635		1.629	1.629	1.631	1.630		
V	1.362	1.372		1.366	1.365	1.365	1.365		
W	0.316	0.321		0.319	0.319	0.319	0.319		
X	1.125	1.145		1.135	1.138	1.137	1.138		
Y	1.565	1.585		1.573	1.575	1.575	1.576		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	Grd	Audited by:	07.02.05
Date:	07/02/12	Date:	SD

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	#

DART AEROSPACE LTD				Work Order: 30280	
Description: 206 Saddle, Outboard, Left side				Part Number: D2932-1	
Inspection Dwg: D2932 Rev. B				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. B and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.127	0.129	0.129	0.128		
B	0.100	0.140		0.129	0.129	0.128	0.129		
C	0.100	0.140		0.122	0.125	0.120	0.120		
D	0.210	0.230		0.224	0.223	0.225	0.225		
E	1.245	1.255		1.249	1.249	1.249	1.249		
F	1.245	1.255		1.249	1.249	1.249	1.249		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.514	.514	.514	.514		
I	1.572	1.582		1.576	1.576	1.576	1.576		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262	DT8683	0.258	0.258	0.258	0.258		
L	0.312	0.317	DT8686	0.314	0.314	0.314	0.314		
M	0.235	0.240		.237	.237	.237	.237		
N	0.100	0.140		0.124	0.124	0.125	0.125		
O	0.540	0.560		0.550	0.549	0.551	0.551		
P	0.490	0.510		0.500	0.503	0.503	0.503		
Q	3.715	3.725		3.718	3.718	3.718	3.718		
R	2.470	2.510		2.485	2.487	2.485	2.485		
S	0.240	0.270		0.253	0.253	0.253	0.253		
T	0.100	0.180		0.140	0.140	0.140	0.140		
U	1.625	1.635		1.629	1.630	1.630	1.636		
V	1.362	1.372		1.366	1.366	1.366	1.366		
W	0.316	0.321	DT8690	0.319	0.319	0.319	0.319		
X	1.125	1.145		1.138	1.137	1.139	1.137		
Y	1.565	1.585		1.577	1.574	1.577	1.574		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	7ml	Audited by:	SA
Date:	07/01/12	Date:	07.02.05

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	#

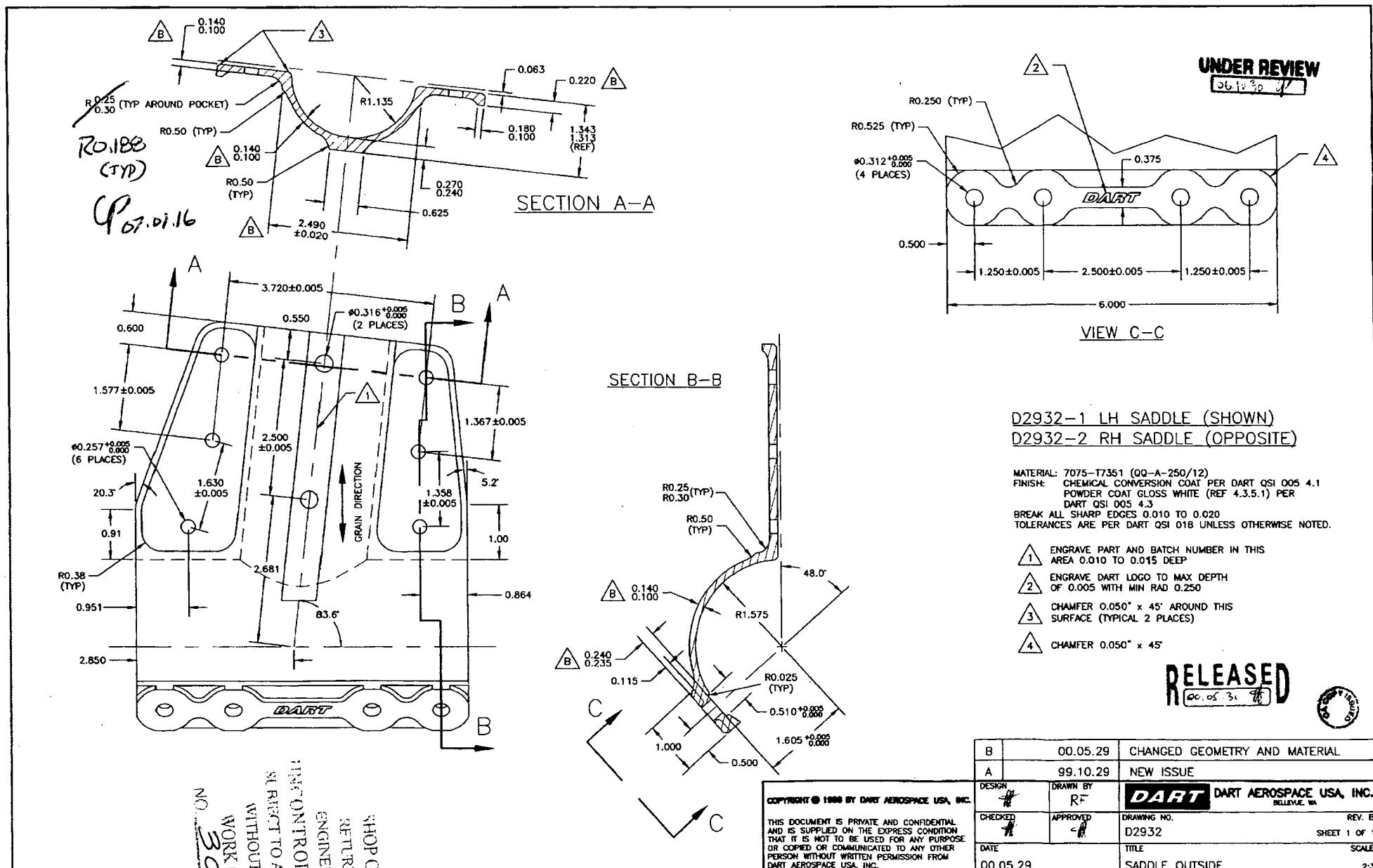
DART AEROSPACE LTD		Work Order:	30280
Description: 206 Saddle, Outboard, Left side		Part Number:	D2932-1
Inspection Dwg:	D2932 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. B and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.128	0.128				
B	0.100	0.140		0.129	0.129				
C	0.100	0.140		0.120	0.118				
D	0.210	0.230		0.225	0.225				
E	1.245	1.255		1.249	1.249				
F	1.245	1.255		1.249	1.249				
G	2.495	2.505		2.499	2.499				
H	0.510	0.515		-514	-514				
I	1.572	1.582		1.576	1.576				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262	DT8683	0.258	0.258				
L	0.312	0.317	DT8686	0.314	0.314				
M	0.235	0.240		0.237	0.237				
N	0.100	0.140		0.125	0.125				
O	0.540	0.560		0.550	0.550				
P	0.490	0.510		0.500	0.503				
Q	3.715	3.725		3.718	3.718				
R	2.470	2.510		2.485	2.485				
S	0.240	0.270		0.253	0.253				
T	0.100	0.180		0.140	0.140				
U	1.625	1.635		1.636	1.636				
V	1.362	1.372		1.366	1.366				
W	0.316	0.321	DT8690	0.319	0.319				
X	1.125	1.145		1.137	1.138				
Y	1.565	1.585		1.575	1.576				
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>jm</i>	Audited by:	<i>SD</i>
Date:	07/01/12	Date:	07.01.05

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	<i>#</i>



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Chris Provencal

From: David Shepherd [dshepherd@dartaero.com]
Sent: October 19, 2006 3:31 PM
To: 'S Shahbazian'
Cc: 'Provencal, Chris'; 'Charbonneau, Eric'
Subject: RE: Radius dimension on the saddle
Importance: High

Change the drawings. I guess we will also change the 0.313 crosstube hole dimensions as well.
See D2661 to D2668 as well as D2932 to D2933.

David

From: S Shahbazian [mailto:sshahbazian@dartaero.com]
Sent: Thursday, October 19, 2006 1:16 PM
To: Shepherd, David
Cc: Provencal, Chris; Charbonneau, Eric
Subject: Radius dimension on the saddle

Dave,
On attach saddle drawing, according to Eric the marked-up radius that reads 0.30 and 0.25, should be 0.188
since the tooling has been changed long time ago, and apparently they have been machining those radiiuses to
0.188 for a while. Do you see a problem with that? if not I will go ahead and change the drawing to reflect the
changes.

Serge

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No virus found in this incoming message.
Checked by AVG Free Edition.
Version: 7.1.408 / Virus Database: 268.13.7/488 - Release Date: 10/19/2006

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